

Work Order ID 104824

July-18-13 3:26:31 PM

*dy Rudy 18/07*

\*104824\*

Page 1

Item ID: D4092-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Maintenance Step Assembly  
 Start Date: 7/18/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 7/19/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4092	B

100	Pick Kit	0.00							
*100*									
Packaging	Memo	0.00				<i>1X</i>			<i>[Signature] 13/07/19</i>
Packaging									

110		0.00							
*110*									
Small Fab	Memo	0.00				<i>1X</i>			<i>[Signature] 13/07/19</i>
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								

120	QC5- Inspect part completeness to step on W/O	0.00							
*120*									
QC	Memo	0.00				<i>1</i>			
Quality Control									

*0.25  
27*

*13719*

# Work Order ID 104824

\*104824\*

Page 2

July-18-13 3:26:31 PM

Item ID: D4092-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Maintenance Step Assembly  
 Start Date: 7/18/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 7/19/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
*130*									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

PPF 104825

IX  
 SP  
 13-7-19

MLJ 13-07-22

MF  
 13-7-22

# Picklist Print

July-18-13 3:26:30 PM

Page 1

Work Order ID: 104824  
Parent Item: D4092-041  
Parent Item Name: Maintenance Step Assembly

Start Date: 7/18/13 Required Date: 7/19/13  
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD IPP REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No			100	Each	17.0000	2	2		7/13/07/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
				77852		1							
				ST241A		1							
				74303		1							
				ST270A		15							
				102366		15							
D4093-1 Bracket		Manufactured	No			100	Each	1.0000	1	1		7/13/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST201		1							
				93754		1							
D4093-3 Bracket		Manufactured	No			100	Each	4.0000	1	1		7/13/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST201		4							
				93253		4							
D4093-5 Bracket		Manufactured	No			100	Each	18.0000	2	2		7/13/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST093		16							
				102355		6							
				102780		10							
				ST139		2							
				99613		2							

# Picklist Print

July-18-13 3:26:30 PM

Page 2

Work Order ID: 104824

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 7/18/13

Required Date: 7/19/13

Start Qty: 1.00

Required Qty: 1.00

MS24694-S54  
SCREW

Purchased No

100 Each 544.0000 2 2

Location

Loc Qty

Loc Code

ST303

544

125535

544

MS24694-S55  
Screw

Purchased No

100 Each 175.0000 8 8

Location

Loc Qty

Loc Code

ST303

175

124296

61

125535

114

MS24694-S56  
SCREW

Purchased No

100 Each 87.0000 2 2

Location

Loc Qty

Loc Code

ST303

87

121340

10

125535

77

NAS1149D0332J  
Washer

Purchased No

100 Each 3,145.0000 12 12

Location

Loc Qty

Loc Code

ST293

83

125268

83

ST294

3062

122973

68

125044

284

m125807

2710

July-18-13 3:26:30 PM

Shop Packet Print

Page 2



# Picklist Print

July-18-13 3:26:30 PM

Page 3

Work Order ID: 104824

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 7/18/13

Required Date: 7/19/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

7,959.0000

12

12

Nut

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

1426

111668

1

117885

32

119017

55

119075

138

123265

43

M126036

1157

ST506

1512

123900

912

124291

600

ST510a

5000

M126275

1000

M126333

4000

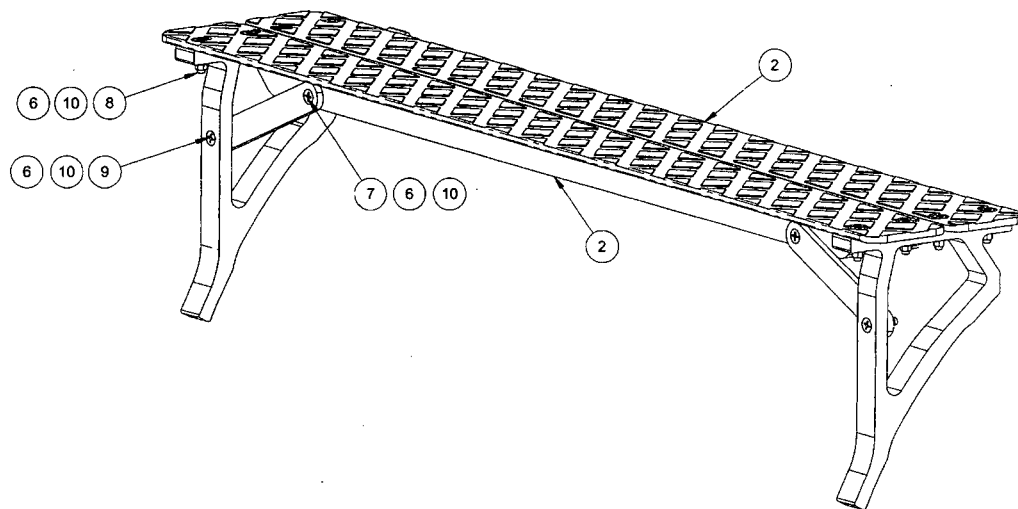
*[Handwritten signature]*  
7/13/04/19

*12*

July-18-13 3:26:31 PM

Shop Packet Print

Page 3



**D4092-041 MAINTENANCE STEP ASSEMBLY**



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

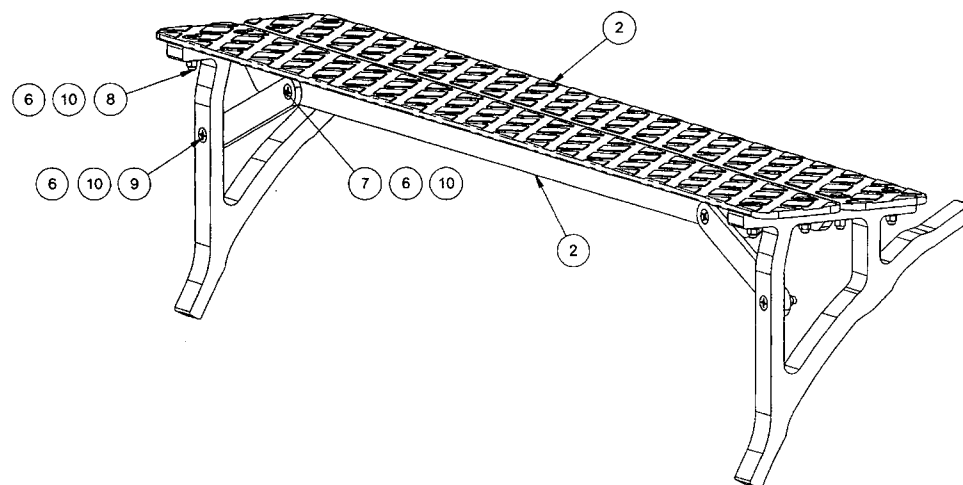
**RELEASED**  
2011-09-22

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.07.27		
<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. D4092 TITLE MAINTENANCE STEP ASS'Y SCALE NTS REV. B SHEET 1 OF 6 COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

*W/O 184824*







**D4092-042 MAINTENANCE STEP ASSEMBLY**

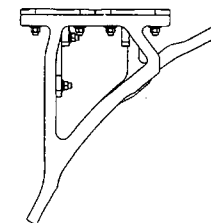
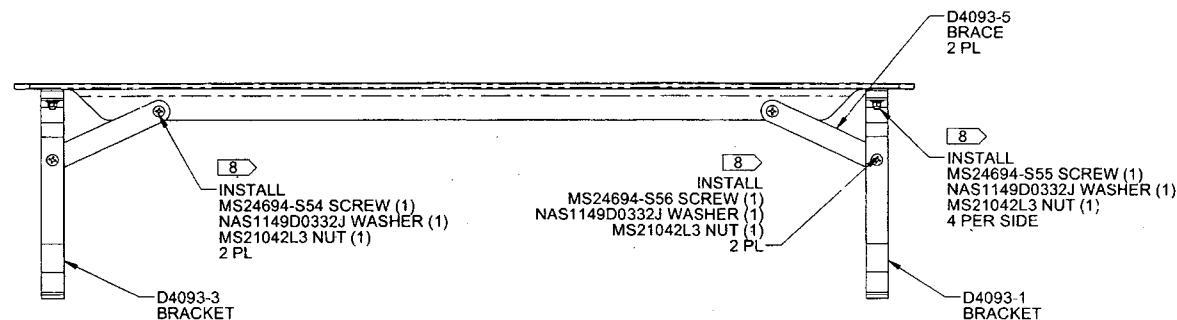
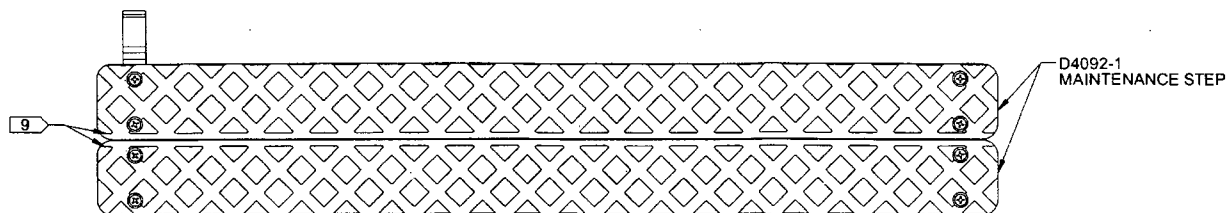
B

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

**RELEASED**  
2011-09-22  
JUN

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4092	SHEET 2 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





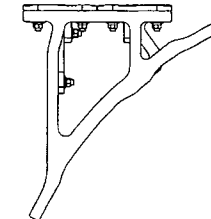
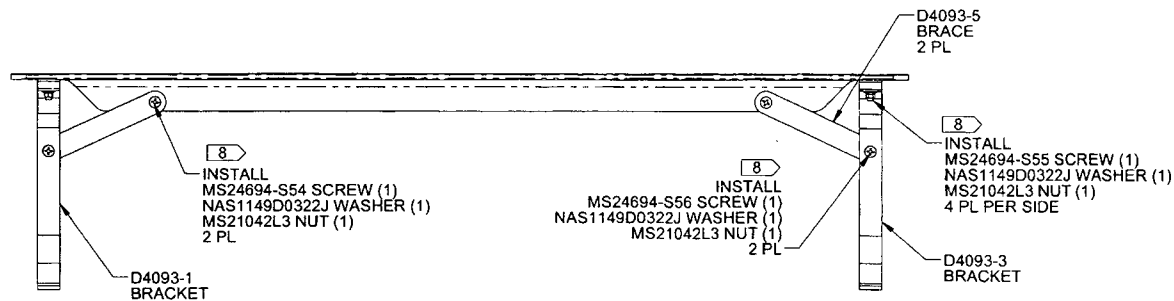
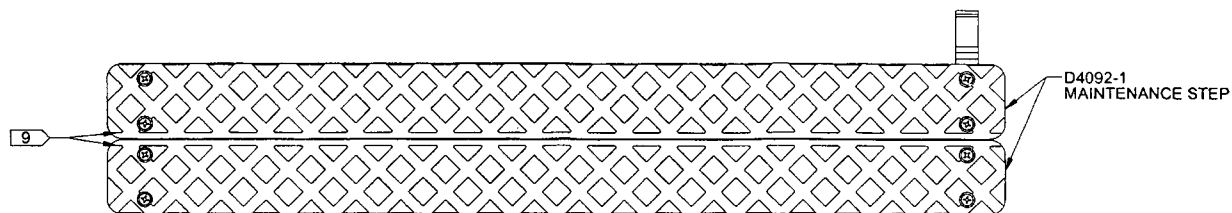
# **D4092-041 MAINTENANCE STEP ASSEMBLY**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER QSI 044 6.1
  - 7) WEIGHT: 5.37 lbs
  - 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
  - 9) GRIP CUTOUT TOWARD CENTER

**RELEASED**  
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 3 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASSY	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





**RELEASED**  
2011-09-22

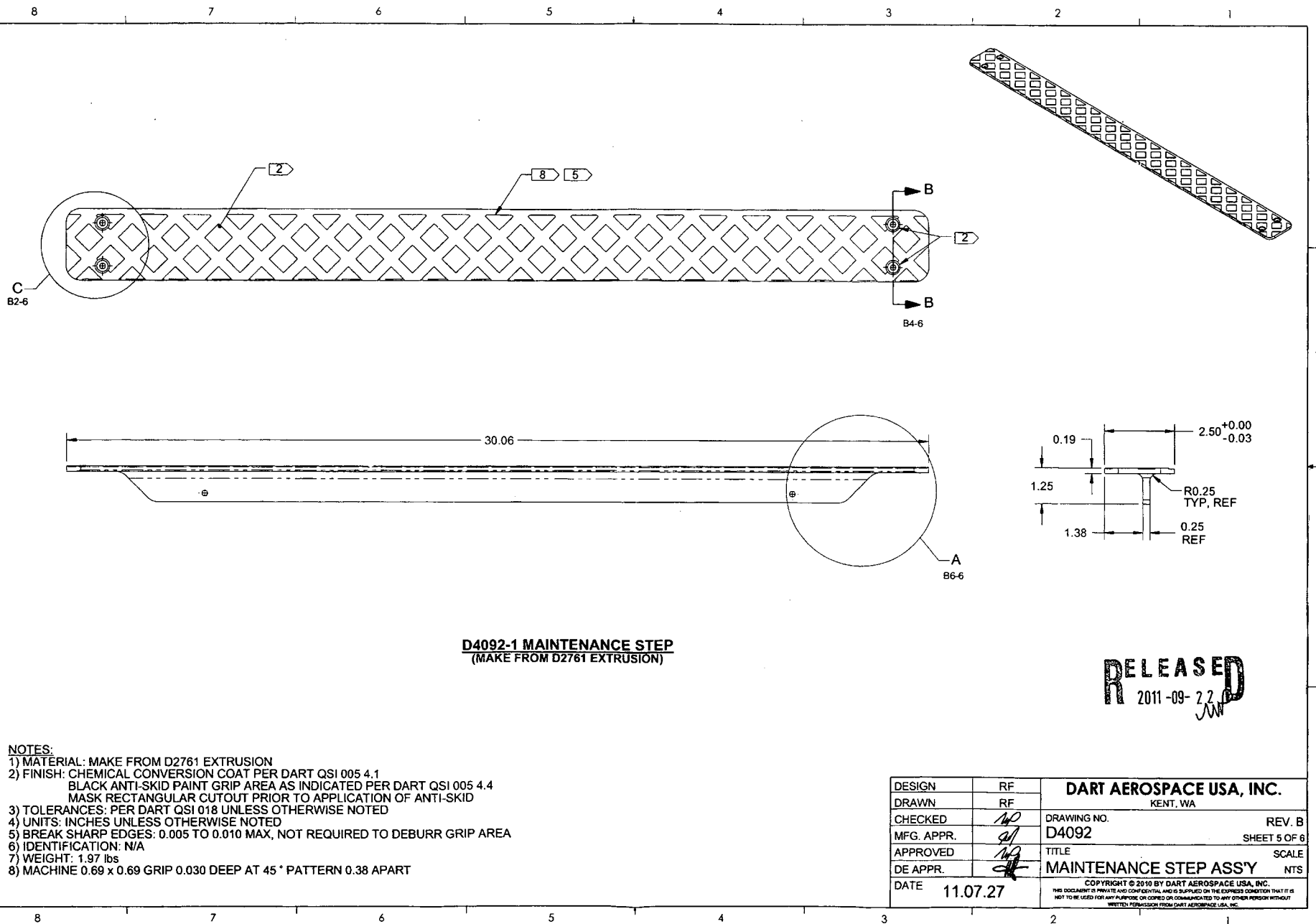
# **D4092-042 MAINTENANCE STEP ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4092	SHEET 4 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





**D4092-1 MAINTENANCE STEP**  
(MAKE FROM D2761 EXTRUSION)

**RELEASED**  
2011-09-22  
JW

**NOTES:**

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4092	SHEET 5 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	<b>MAINTENANCE STEP ASSY</b>	
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

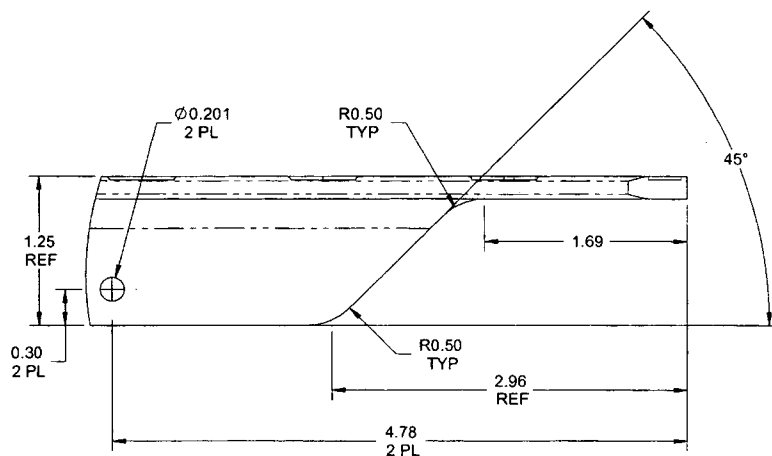
8 7 6 5 4 3 2 1

D

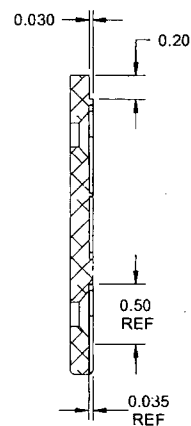
C

B

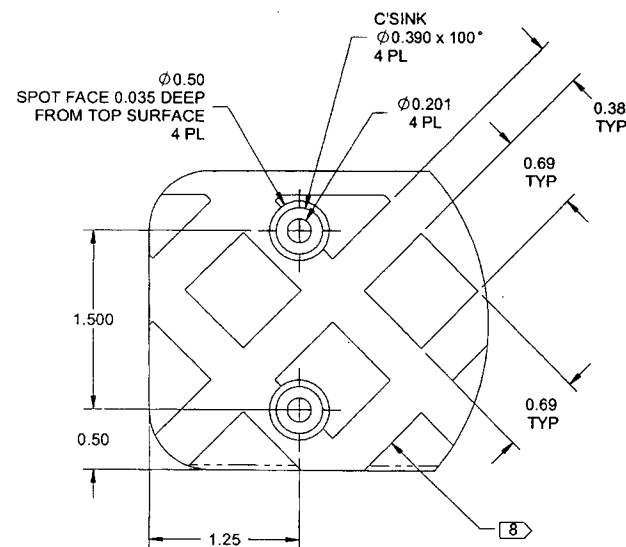
A



**DETAIL A** B3-5  
SCALE 3X, TYP



**SECTION B-B** C3-5  
SCALE 3X, TYP



**DETAIL C** C8-5  
SCALE 3X, TYP

**RELEASED**  
2011-09-22  
MWO

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>81</i>	D4092	SHEET 6 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBINED WITH ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



